

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013794**Date Inspected:** 18-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (7BE)**

During random in process observations of Floor Beam FB14B and Bottom Plate BP171A for Segment 7BE, this Caltrans Quality Assurance Inspector observed the following issues:

-In surface flatness measurement, the Floor Beam panel has a distortion of 24mm between 3rd and 4th T-Rib when measured with a string line over the height of that floor beam (~370mm) section at panel point (PP) 52, near E2 location.

-Segment 7BE is located in the OBG Trial Assembly yard.

For further information, please reference the attached pictures.

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed dimensional check on deck panel diaphragm using 710mm straight edge and right angle to check plumpness and flatness for below segment. Reports forwarded to team leader for further action

7CW-PP 53, PP54 and PP55

7DW -PP 56, PP57 and PP58

7EW-PP59 and PP60.

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## WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (8BW)

SMAW Process:

Welding of weld joint – 004 located on PCMK CA049, corner assembly longitudinal weld joining Deck panel and Edge panel at crossbeam side. Welder is identified as 050232. ZPMC CWI is identified as Li Yang. Welding was performed against critical welding repair report B-CWR1387. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (8BW)

SMAW Process:

Welding of weld joint – 004 located on PCMK CA049, corner assembly longitudinal weld joining Deck panel and Edge panel at crossbeam side. Welder is identified as 048047. ZPMC CWI is identified as Li Yang. Welding was performed against critical welding repair report B-CWR1387. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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